

Date: Thursday, 2/8/2007 12:05:01 PM
User: Kim Johnston

Process Sheet

| | | | |
|-------------------------|--------------------------------------|--------------------|------------------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | 3" SKID EXTRUSION (NO OUTER RIDGE) |
| Job Number : | 30682 | | |
| Estimate Number : | 10054 | | |
| P.O. Number : | N/A | Part Number : | D26003120 |
| This Issue : | 2/8/2007 | S.O. No. : | N/A |
| Prsht Rev. : | NC | Drawing Number : | D2600 REV D1 |
| First Issue : | N/A | Project Number : | N/A |
| Previous Run : | 26205 | Drawing Revision : | D1 |
| | | Material : | N/A |
| Written By : | | Due Date : | 2/28/2007 |
| Checked & Approved By : | <u>07.02.08</u> | Qty: | 80 |
| Comment : | Est. D. 02.09.10 Added DSK 066 KJ/RF | Um: | 140 |
| | | | Each |

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 3090

07/02/09
80

- a) Extrude as per Dwg D2600
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 40 ksi
- e) Minimum elongation = 8%
- f) Order at 120" long
- g) Bon L Canada Inc. tool # 897122
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

2.0 D26003120P Extrusion Round 3" 350



Comment: Qty.: 1.0000 Each(s)/Unit Total : 140.0000 Each(s)
Extrusion Round 3" 350

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure material certification is attached

07/02/20
78

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimension per Dwg D2600
Check Pull test per Dwg D2600 for compliance page attached
Check hardness with Webster tester

07/02/28
78

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 07/03/01
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 2/8/2007 12:05:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" SKID EXTRUSION (NO OUTER RIDGE)

Job Number: 30682

Part Number: D26003120

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Back Hall

JD 7-2-28

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

9 07/03/01

Job Completion



u 07-02-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2600 | REV. D SHEET 1 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |
| A | 97.01.21 | NEW ISSUE | |
| B | 97.09.09 | CHANGE MATERIAL SPEC. | |
| C | 98.04.16 | ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO. | |
| D | 98.08.20 | INCREASE MIN. UTS TO 40 KSI | |
| D1 | 01.04.17 | ADD PART NUMBERS + DIE NUMBERS <i>46P</i> | |

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

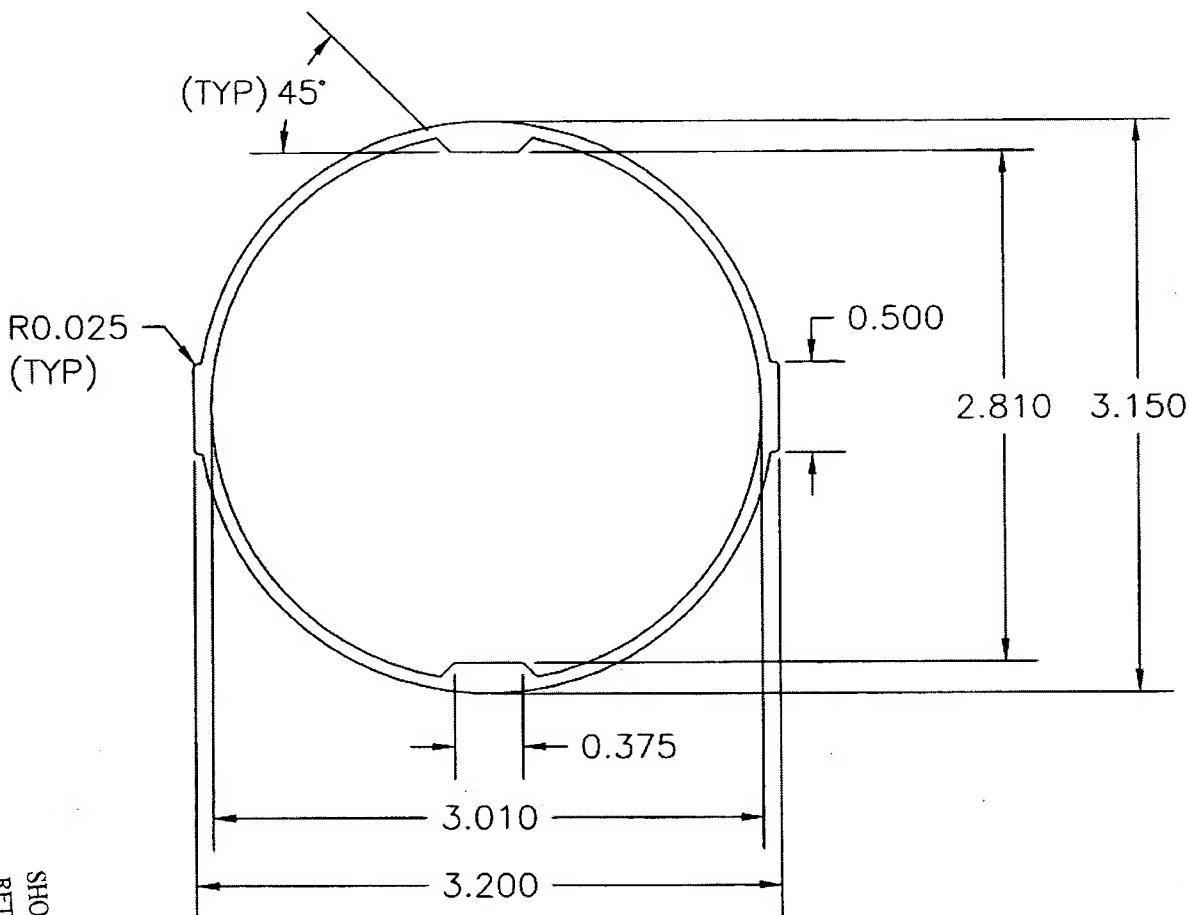
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NO. 30682

DART



| | | | |
|----------------------|-----------------------|---|--------------|
| DESIGN <i>WJ</i> | DRAWN BY <i>WJ</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>WJ</i> | DRAWING NO. D2600 | REV. D |
| DATE 98.08.20 | | TITLE EXTRUSION | SHEET 2 OF 5 |
| | | | SCALE 1:1 |

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98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

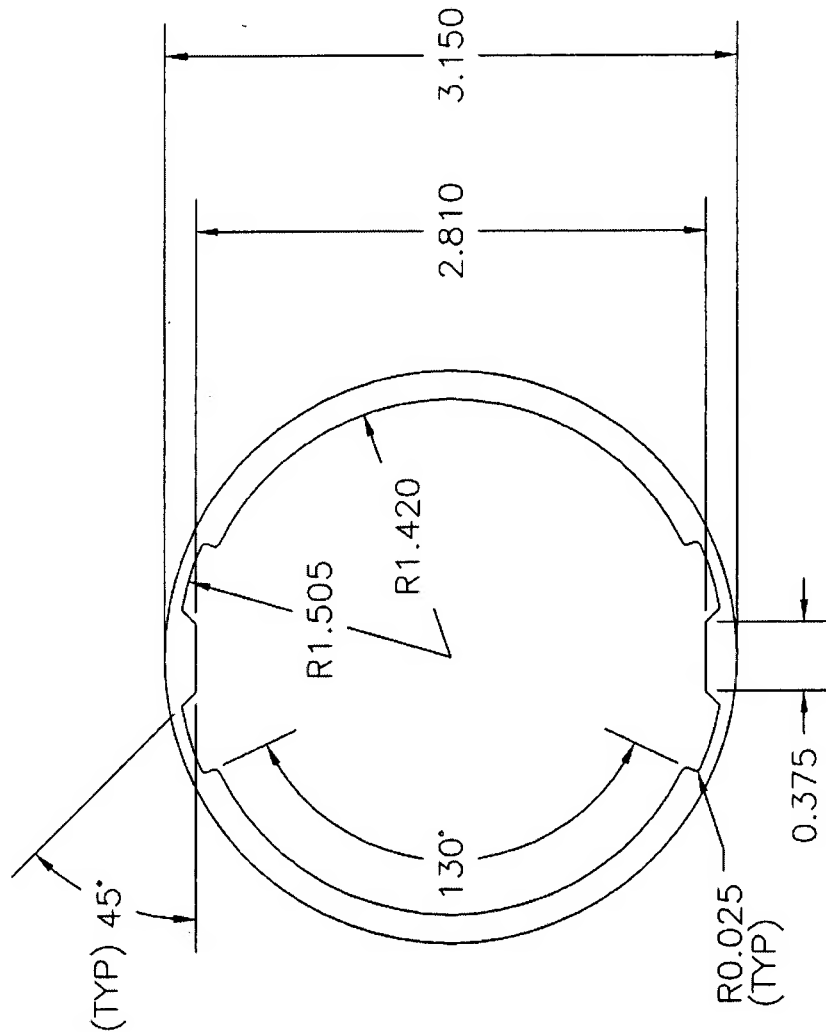


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| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2600 | REV. D SHEET 3 OF 5 |
| DATE 98.08.20 | TITLE EXTRUSION | | SCALE 1:1 |

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98.8.25 DS



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BON L DIE # 897122 (PREFERRED CHOICE)
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)

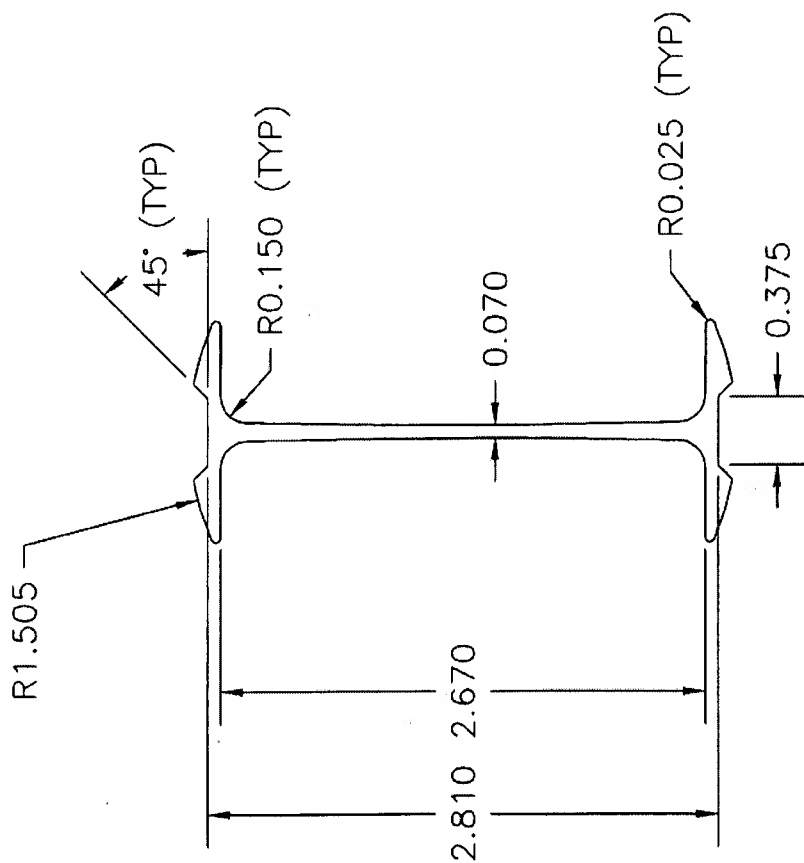
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| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>MB</i> | DRAWN BY <i>MB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>KE</i> | DRAWING NO. D2600 | REV. D SHEET 4 OF 5 |
| DATE 98.08.20 | TITLE EXTRUSION | | SCALE 1:1 |

RELEASED
98.8.25. DS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)

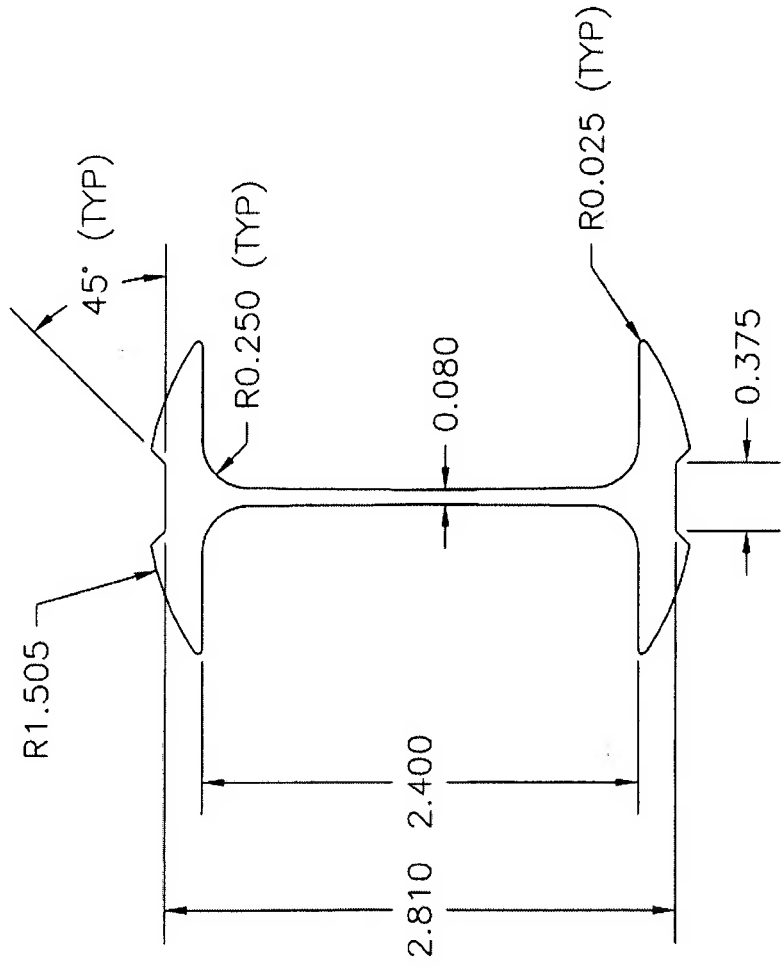


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NO. 30682



| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>ME</i> | DRAWN BY <i>ME</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>KE</i> | DRAWING NO. D2600 | REV. 0 SHEET 5 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |

RELEASED
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)

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NO. 30682



CERTIFICATE OF COMPLIANCE

BON L CANADA INC

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

| Card Date | Card No | Sales Order | Page |
|-----------|----------|-------------|---------|
| 02/19/07 | 155268 | 58533 | 1 |
| Card No | Part No | Lot | Date |
| 00003090 | 00335009 | 58533010 | 2/19/07 |

| Sold To | Ship To |
|---|---|
| 46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 | 46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 |

| Item No | Part No | Item Description | Cust Part |
|-------------------------------|-----------------------------|-------------------|-------------|
| 1.000 | DAA-897122-1 | 120" Mill 6061 T6 | D2600-3-120 |
| Gross Weight | 1257 LBS | | |
| Net Qty | 1,217 LB 78 PC 780 FT 2 PKG | | |
| Specification | Dia Desc | | |
| AMS-QQ-A-200/8 & ASTM B221-00 | | | |

Mechanical Tests:

| Test No. | Tensile MPA / KSI | Yield MPA / KSI | %Elongation | Conductivity | Bend/Drift HREW |
|----------|-------------------|-----------------|-------------|--------------|-----------------|
| 1 | 322.8 / 46.9 | 304.5 / 44.2 | 12.3 | .0 | 97 |

Chemical Limits:

| | SI | FE | CU | MN | MG | CR | ZN | TI | OTHER |
|------|-----|-----|-----|-----|------|-----|-----|-----|----------|
| MIN: | .40 | .00 | .15 | .00 | .80 | .04 | .00 | .00 | EA: .05 |
| MAX: | .80 | .70 | .40 | .15 | 1.20 | .35 | .25 | .15 | TOT: .15 |

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Conchita Ko, QA Manager Signed for Bon L Canada

07/02/28

Conchita Ko.